

Work Order ID 85619 - 1

85619

Page 1

June-12-12 8:51:03 AM

Item ID: D3910-1

Revision ID:

Item Name: Crosstube Lug

Start Date: 12/06/2012 Start Qty: 30.00

Required Date: 26/06/2012 Req'd Qty: 30.00

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS

QC:

Date: 12/06/12 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3910

B

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

cut @ meter

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: _____

DWG REV: _____

0.00

DEBURR

D/O: 17214

CL 12/06/13

CL 12/06/13 (80)

issue #10: to meter
machine as per drawing D3910 REV.B

[Signature]

Work Order ID 85619

85619

Page 2

June-12-12 8:31:04 AM

Item ID: D3910-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug

Start Date: 12/06/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120
120
QC
Quality Control

QC2-Inspect parts off machine FA/FAIB

0.00

Memo

0.00

need + inspect for tensile damage
attached c/c to W/O

12/12/16 (22)

130
130
QC
Quality Control

QC8-Inspect parts - second check

0.00

Memo

0.00

DAS
16
8-8 12/12/16

out
(22)

140
140
HandFinish
Hand Finishing

Chemical Conversion Coat per QSK005 4.1

0.00

Memo

0.00

22 12/12/16

Work Order ID 85619

June-12-12 8:51:04 AM

85619

Item ID: D3910-1

Revision ID:

Item Name: Crosstube Lug

Start Date: 12/06/2012 Start Qty: 30.00

Required Date: 26/06/2012 Req'd Qty: 30.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

N9000040100

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

150

150

Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

170

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

22x

φ

M.L
12/07/16

22

φ

BL/27/16

12/27/16 (22)

ST
607

Order ID 85619

85619

8:51:04 AM

D3910-1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

12/06/2012

Crosstube Lug

12/06/2012 Start Qty: 30.00 *30*

Cust Item ID:

Date: 26/06/2012 Req'd Qty: 30.00 *30*

Customer:

Status

Run Start *NR1*

Stop *NR2*

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

D/ter ID

Operation Description

Set Up/Run Hours

Tool ID

Tool #

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

QC21- Final Inspection - Work Order Release

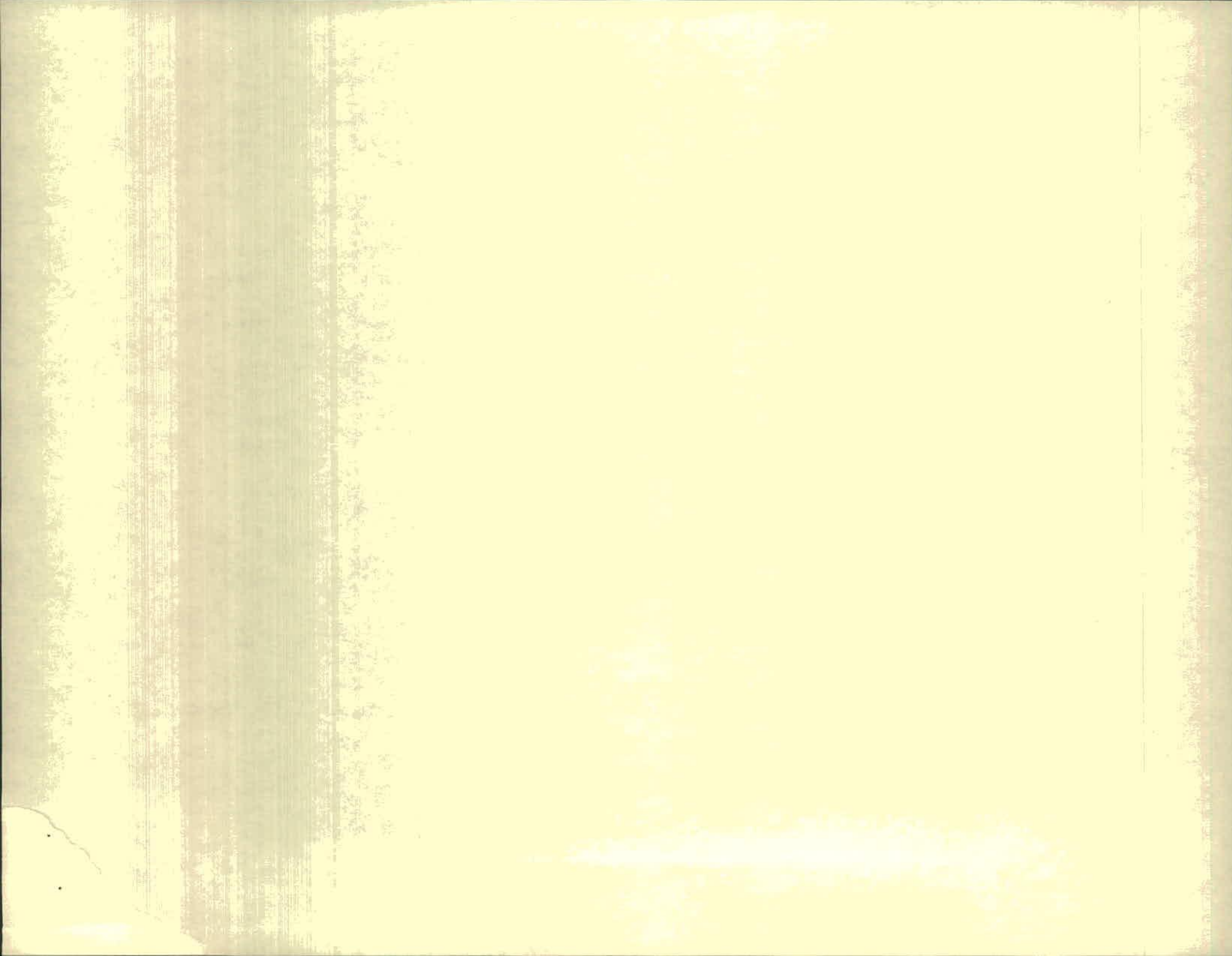
0.00

*

Memo

0.00

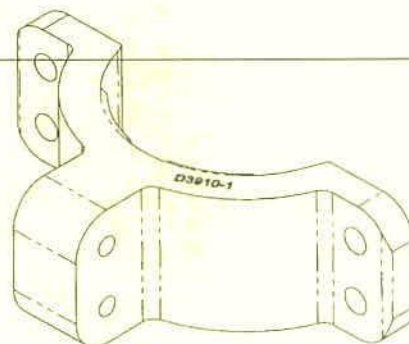
12/7/18
ME
12-07-15



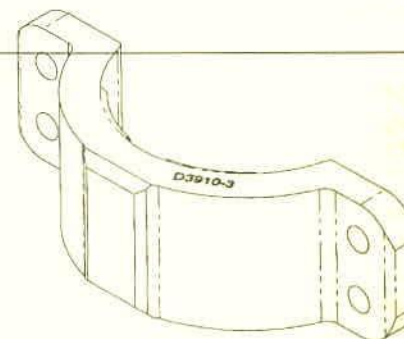
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85619 M-5

12/06/12



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED
2010-03-22
MP

NOTES:

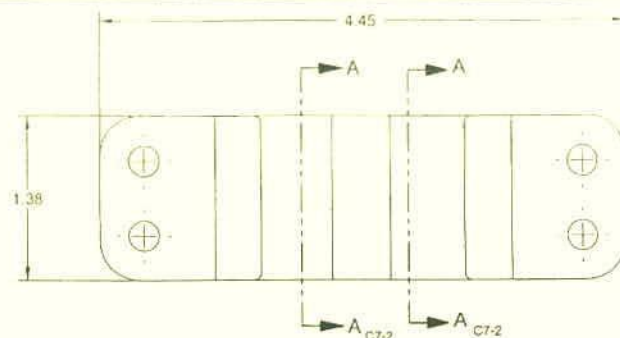
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.251 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3), R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D3910-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE RELEASED OR DISCLOSED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		

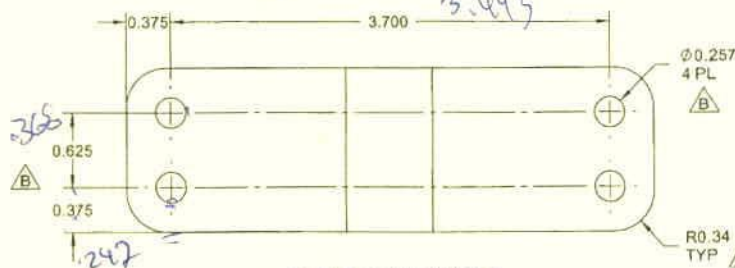
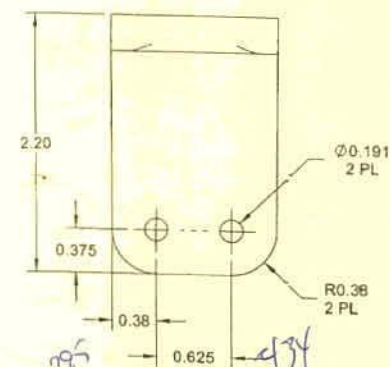
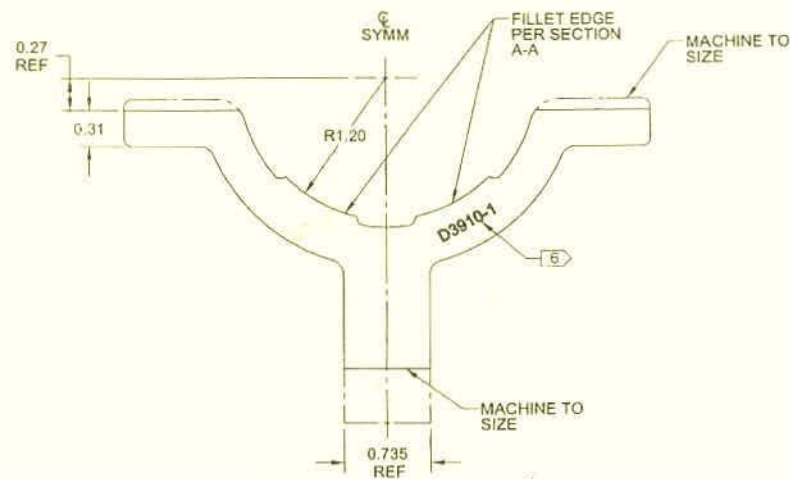
85019



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL



SECTION A-A
C4-2
CS-2



D3910-1 X-TUBE LUG

RELEASED
2010-03-22

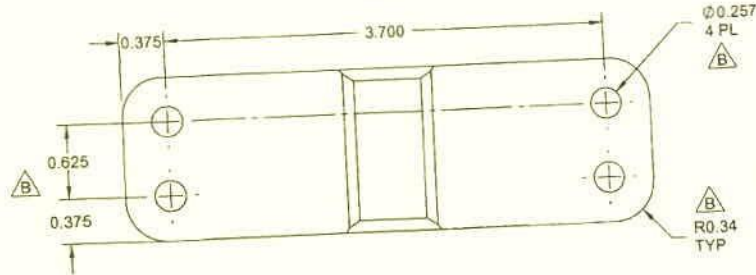
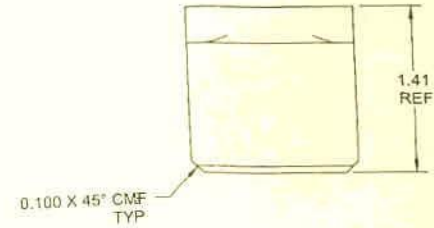
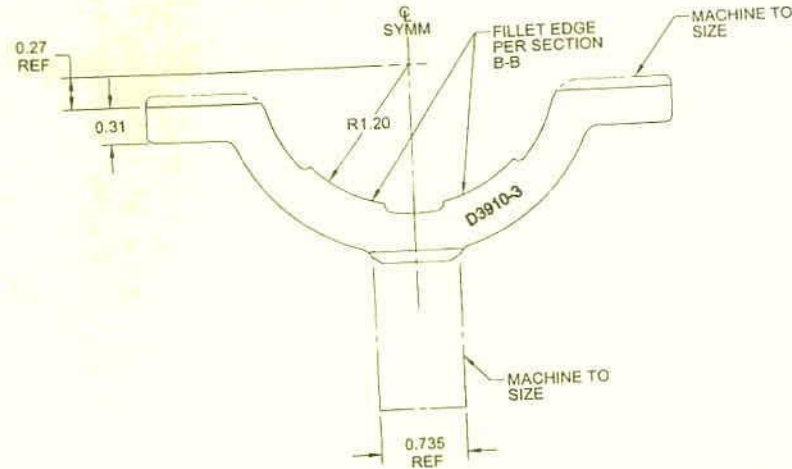
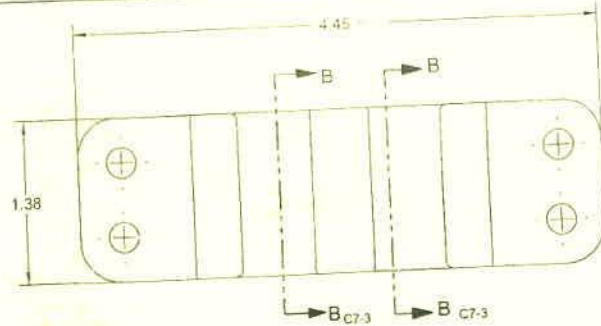
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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25619



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID: PO17216

Purchase Order Date: 6/13/12

PO Print Date: 6/14/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED
FAXED
6/20/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-1P	CROSSTUBE LUG	6/29/12 Yes	60.00 Each		\$31.5500	\$1,893.00

Special Inst: AS PER DWG D3910 REV. B
B85619

PO Total:

\$1,893.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

2

Change Date: 6/14/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18580
Date: Jul 13, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 17216	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jul 13, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug as per dwg D3910 REV.B B58619	Each	60	22	38
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
22	D3910-1	Lug	17216

JAS 16 9-83
17/07/12
MATERIAL: supplied by DART B81557

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 13, 2012

